

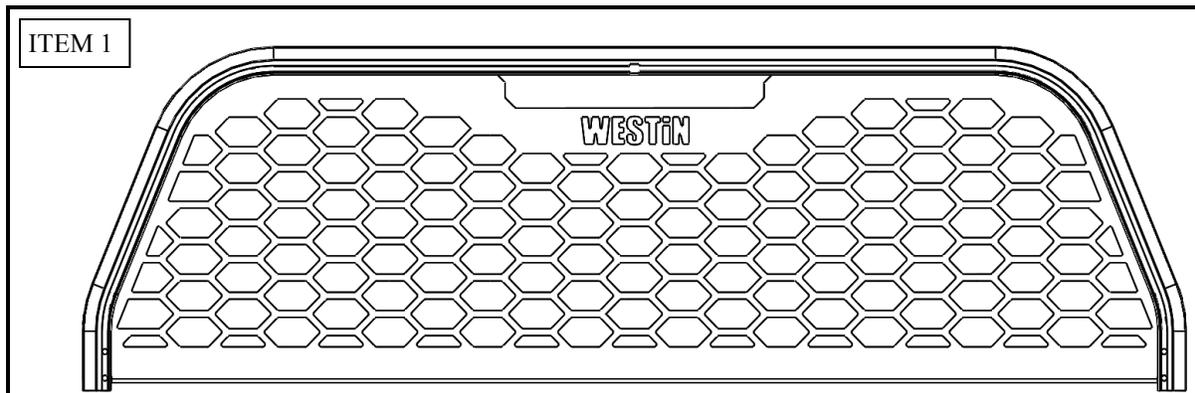
# INSTALLATION INSTRUCTIONS

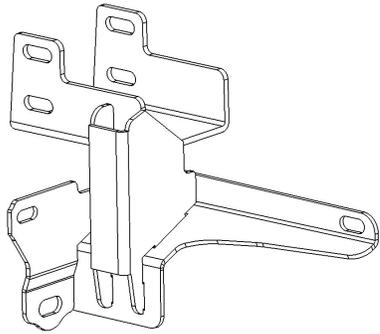
## HLR TRUCK RACK



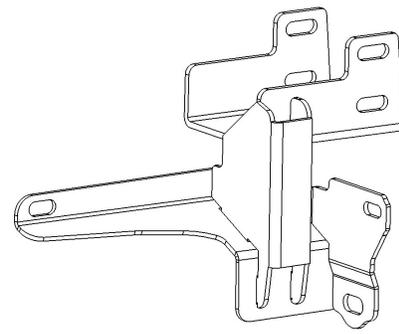
**APPLICATION:**  
2007-2018 Toyota Tundra  
**PART NUMBER:**  
57-81075

CONTENT			
ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
1	1	Hoop/Screen Assembly	10 mm Wrench
2	1	Mounting Bracket (Driver's Side)	10 mm Socket
3	1	Mounting Bracket (Passenger's Side)	1/4" Drive Ratchet
4	3	Nylon Spacer Large	17mm Wrench
5	10	Nylon Spacer Small	17mm Socket
6	4	M8 Hex Head Bolt	Impact
7	8	M8 Flat Washer	13mm Socket
8	4	M8 Hex Nut Nylock	13mm Wrench
9	14	M6 Split Lock Washer	
10	14	M6 Flat Washer	
11	14	M6 Button Head Bolt	
12	2	M10 Rivcert	
13	2	M10 Hex Head Bolt	
14	2	M10 Split Lock Washer	
15	2	M10 Flat Washer	
16	1	M10 Rivcert Tool	





ITEM 2



ITEM 3

### PROCEDURE

1. Remove contents from box, verify if all parts listed are present and free from damage. Carefully read and understand all instructions before attempting installation.  
**Failure to identify damage before installation could lead to a rejection of any claim.**

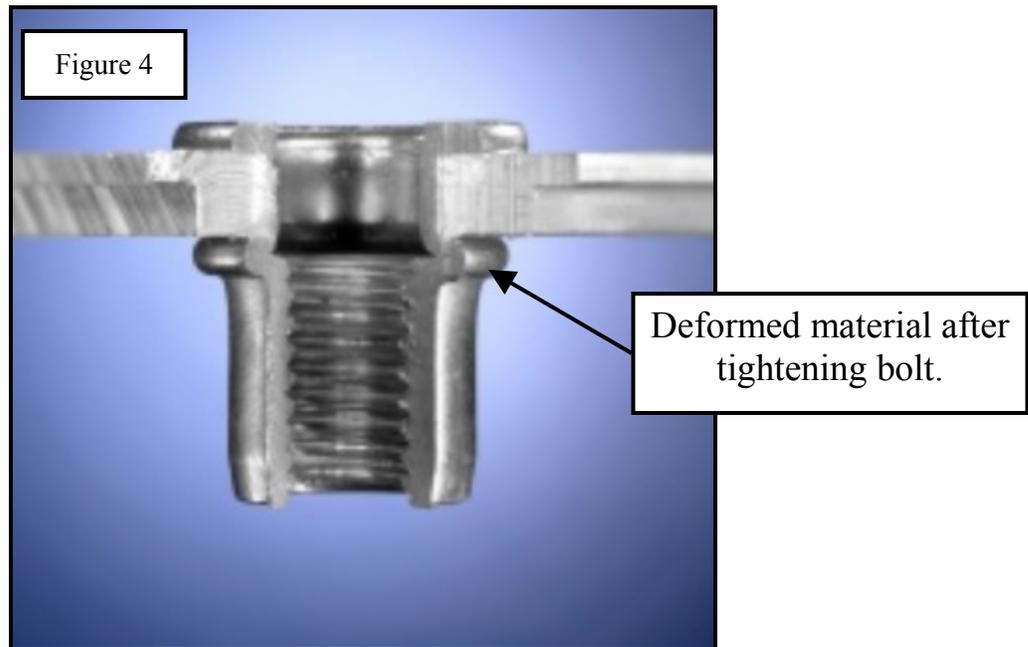
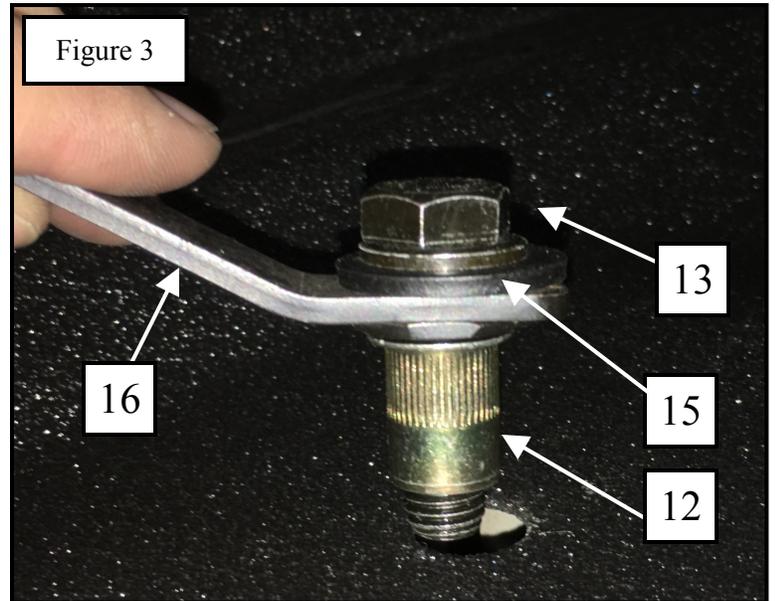
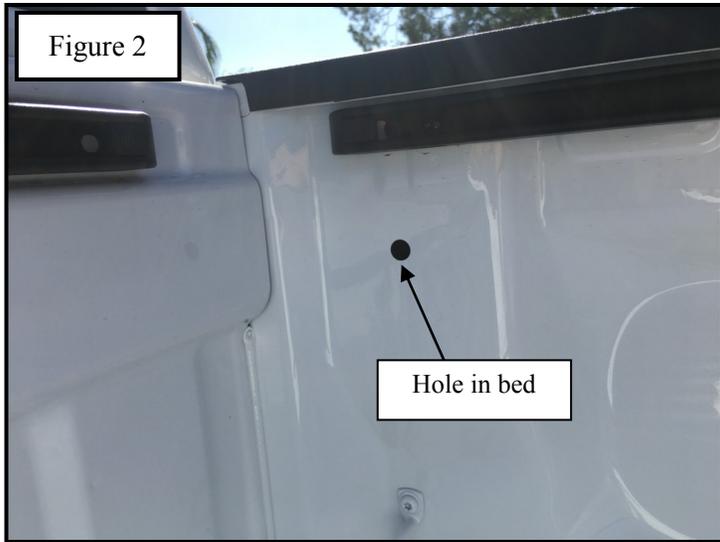
2. Begin installation by removing OEM rails bolted to the bed of the truck. Remove the two side rails and the front rail. See **Figure 1**.



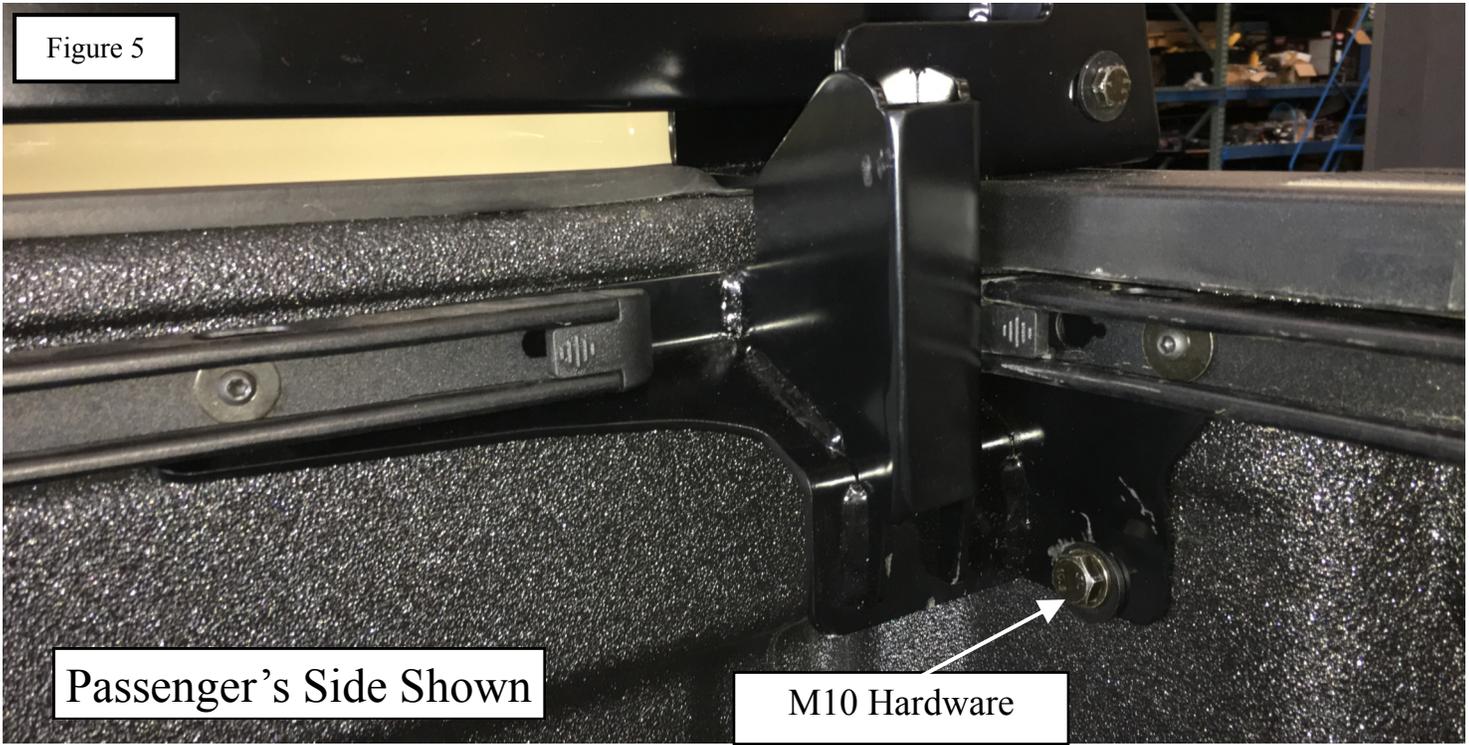
3. Identify the two round holes on the side of the bed of the truck. **See Figure 2.** The riv-certs will be installed in these holes.

4. To install Riv-cert, assemble as shown in Figure 3. Then, insert into hole and apply FIRM pressure against the side of the bed as you tighten the M10 bolt with a 17mm socket. Using an impact is strongly recommended but not necessary.

As you tighten the bolt, it will “pull” the riv-cert towards the bed panel and eventually “sandwich” the bed panel between the riv-cert frontal flange and the deformed material. See **Figure 4.**



5. Next, proceed to position the brackets on the front corners of the bed. See Figure 5.
6. Insert the M10 hardware on the riv-certs installed on the previous step to hold the bracket in place while OEM rails are installed back in position.



7. To install OEM bed rails, insert supplied spacers behind the rails according to diagram below. Repeat for opposite side. See Figure 6. Use supplied M6 hardware items 9-11 to install bed rails. The OEM M6 bolts may be too short.

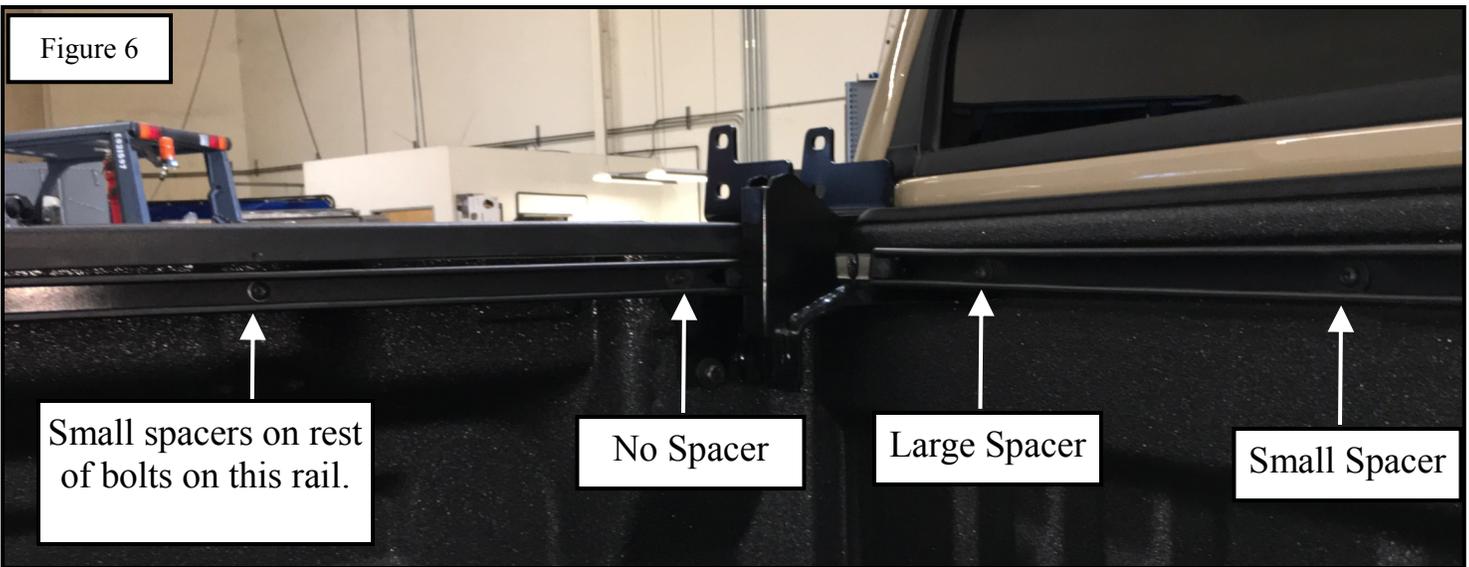
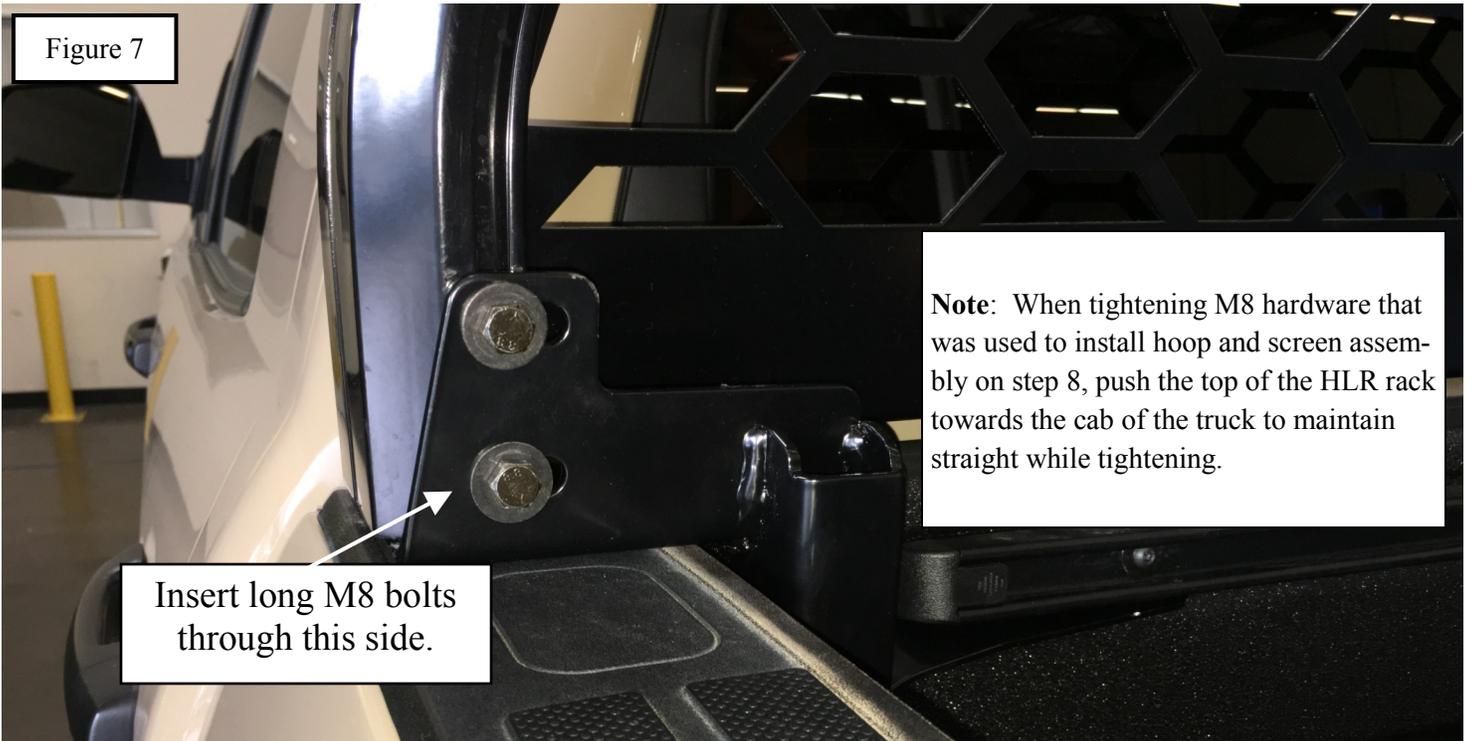


Figure 7



8. Next, position headache rack on brackets and fasten using M8 hardware items 6-8. See Figure 7.

9. Once everything is in position, torque all hardware; M6 to 8-11 ft-lb, M8 to 15-18 ft-lb and M10 to 30-35 ft-lbs.

**INSTALLATION COMPLETE**





## WARNING



Failure to follow these instructions could lead to death, personal injury, and / or property damage.

Failure to follow these instructions could lead to death, personal injury, and / or property damage.

### FASTENERS:

All Westin supplied fasteners must be utilized and installed in accordance with the installation instructions and apply torque to the specifications as defined. **DOUBLE CHECK ALL FASTENERS BEFORE INITIAL USE, AND PERIODICALLY IN THE FUTURE TO ENSURE PROPER FUNCTION AND SAFETY.**

### DRILLING:

Most Westin products do not require drilling for installation. If drilling is defined as required, use caution when drilling a vehicle. **FAILURE TO REVIEW AN AREA TO BE DRILLED MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

### EYE PROTECTION:

**ALWAYS WEAR SAFETY GLASSES OR GOGGLES DURING THE INSTALLATION PROCESS TO AVOID PERSONAL INJURY.**

### MAXIMUM TOWING/CARRYING CAPACITY:

The Westin Receiver Hitches will have a visible tow rating label affixed directly on the product. User should never exceed the vehicle manufacturers maximum tow and weight rating regardless of the capacity of the hitch. **FAILURE TO FOLLOW THESE GUIDELINES WILL VOID THE WESTIN WARRANTY AND MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**



Westin Automotive Products, Inc.  
320 W. Covina Blvd  
San Dimas, Ca. 91773

Thank you for choosing Westin products  
for additional installation assistance please call  
Customer Service (800) 793-7846

[www.westinautomotive.com](http://www.westinautomotive.com)